

Date: Monday, 3/13/2006 7:29:37 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HELI-RAPPEL INSTALLATION
<b>Job Number</b> : 26200	
<b>Estimate Number</b> : 12261	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D205523013
<b>This Issue</b> : 3/13/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : DSI9301 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL / MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 26014	<b>Material</b> : N/A
<b>Written By</b> : <u>See comment below</u>	<b>Due Date</b> : 3/17/2006 <b>Qty:</b> 5 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>06.03.13</u>	
<b>Comment</b> : Est. B 02.04.04 Updated Drawing and Added Inspection Level 21 SM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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06.03.21

**Comment:** DOCUMENT CONTROL

Photocopy blue file &amp; type labels as per PPP D205-523-013, CHG 002

See attached

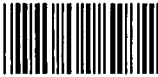
2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

✓

3.0	D205523043	Slide Bar Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Heli-Rappel Installation

Pick:

Qty	Part Number	Description	Batch
1	D205-523-043	Rappel anchor	B26215 ✓

06/07/12

4.0	D2224	Rappel Anchor Assembly
-----	-------	------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rappel Anchor Assembly

Pick:

Qty	Part number	Description	Batch
1	D2224	Rappel anchor	B27245 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:

Monday, 3/13/2006 7:29:37 AM

User:

Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-RAPPEL INSTALLATION

Job Number: 26200

Part Number: D205523013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2229

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Doubler

Pick:

Qty Part number Description Batch

2 D2229

Doubler

B17569 ✓

6.0

AN513A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty Part number Description Batch

4 AN5-14A

Bolt

M17566 ✓

7.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty Part number Description Batch

8 AN960JD516

Washer

M19185 ✓

8.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty Part number Description Batch

4 MS21042-5

Nut

M17694 ✓

AR 06/07/18 (5)

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AR 6/7/20 (5)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D205-523-013

Identify and Stock

Location: \_\_\_\_\_

NEUC

AR 6/7/20 (5)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/07/24

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: HELI-RAPPEL INSTALLATION

Job Number: 26200

Part Number: D205523013

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.21

Job Completion



06.07.20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AA</i>	APPROVED <i>AA</i>	DRAWING NO. DSI 9301	REV. A SHEET 1 OF 1
DATE 05.05.11		TITLE RAPPEL ANCHOR INSTALLATION	SCALE NTS
A	05.05.11	NEW ISSUE	

## **DART SERVICE INSTRUCTION**

### **TO AMEND INSTALLATION INSTRUCTIONS D205-523 REV. F**

REF. CANADIAN STC: SH96-90 ISSUE 3

REF. FAA STC: SR00511NY, SR00512NY, SR00513NY

It has come to DART's attention that in general, AN5-13A bolts are a more suitable length for installation of the D2224 Rappel Anchor (ref) in place of the AN5-14A bolts referred to in D205-523 Rev.F.

It is acceptable to install the D2224 Rappel Anchor (ref) using longer or shorter AN5 bolts as needed to suit the thickness of the rotorcraft's ceiling panel. It is acceptable to use a light AN960JD516L washer under the head of the bolt instead of an AN960JD516 washer per D205-523 Rev. F. However, to preserve the structural integrity of the system, the washer under the MS21042L5 nut must remain an AN960JD516 washer.

For all cases, ensure the bolts properly secure the D2224 Rappel Anchor (ref) to the rotorcraft's ceiling and each bolt has at least 2 threads in safety.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26200

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
<b>APPROVED</b>	
BY: <i>D. Shepherd</i>	
D. SHEPHERD (DE # 02)	
DATE:	<u>05.05.11</u>
CERT. NO.:	<u>SH96-90</u>
ISSUE NO.:	<u>3</u>

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